

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029145**Date Inspected:** 11-Feb-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** USA Hoist**Location:** USA Hoist, Crest Hill, IL

<b>CWI Name:</b>	Robert Zimny		
<b>Inspected CWI report:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A

<b>CWI Present:</b>	Yes	No
<b>Rod Oven in Use:</b>	Yes	No N/A
<b>Weld Procedures Followed:</b>	Yes	No N/A
<b>Verified Joint Fit-up:</b>	Yes	No N/A
<b>Approved WPS:</b>	Yes	No N/A
<b>Delayed / Cancelled:</b>	Yes	No N/A
<b>Component:</b>	SAS Tower Elevator	

**Bridge No:** 34-0006**Summary of Items Observed:**

Caltrans Office of Structural Material (OSM) Quality Assurance Inspector (QAI) Joselito Lizardo was present at USA Hoist, Crest Hill, IL as requested to perform observations on the welding of components for the San Francisco Oakland Bay Bridge (SFOBB) Project.

At USA Hoist fabrication shop, welding foreman Genaro Ulloa was noted continuing to erect the temporary frame for the trial fit up of six (6) elevator door stops enclosure frame assembly before sending them for hot dipped galvanizing. During the conversation with the foreman, he mentioned that USA Hoist wants to make sure that the assembly will fit correct accordingly and the installed camber will be noted. The welder has tack welded one beam on left and right sides of the work table then bolted the hinged frame and fixed frame to the beams. The erection of the temporary frame for the trial fit up of the 6 elevator door stop enclosures was completed today.

This QA had a telephone conversation with Structural Materials Representative (SMR) Yiannis Kourakis with regards to the status and progress of the tower elevator project. During the conversation, it was mentioned to the SMR the following status;

1. Fabrication of WT6 x 10 to angular 3" x 3" for six door frames stops 1 thru 6 completed.
2. Fabrication of C200 x 20.5/C180 x 18.2 to angular L6.4 x 6.4 x 9.5 for six door enclosure stops 1 thru 6 completed.
3. Cutting and drilling of holes on angular L178 x 102 x 12.7 (one pair) mounting angle/bracket for six door

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enclosure stops 1 thru 6 completed.

4. Cutting and notching various sizes and shapes of formed and standard C-channels, flat bars for elevator cab completed. Awaiting welding shop drawing from Bob Overbeek USA Hoist Engineer.
5. Received and QA released "OK to cut" tube steel 6" x 6" x 0.375 ASTM A500 grade B for the elevator support mast. Also awaiting dimensional shop drawing from Bob Overbeek USA Hoist Engineer prior to cut.

### Anticipated Issues:

1. USA Hoist plans to use mild steel weld-on hinge instead of stainless steel stated on the USA Hoist approved shop drawing (914900). But original Caltrans contract drawing also specifies galvanized steel fixed pin weld-on hinge. Per conversation with Tim Moran USA Hoist Project Manager, they are aware of it and this has already been discussed with Caltrans.
2. USA Hoist also plans to use hot dipped galvanized wire mesh for the elevator doors instead of welded stainless steel wire mesh which was stated in USA Hoist approved drawing 914912. Per conversation with Tim Moran USA Hoist Project Manager, they are aware of it and this has already been discussed with Caltrans.

### Summary of Conversations:

Per conversation with Mr. Tim Moran USA Hoist Project Manager, he informed this QA that the material changes that will be done as mentioned above will be updated in their shop drawing and then submit them for Caltrans approval.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Lizardo, Joselito	Quality Assurance Inspector
<b>Reviewed By:</b>	Foerder, Mike	QA Reviewer

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